

# Work Order ID 115973

Friday, April 04, 2014 1:59:47 PM

**\*115973\***

Page 1

Item ID: D4030-041	Accept	<b>*N900040100*</b>	Setup Start	<b>*NS1*</b>
Revision ID:			Stop	<b>*NS2*</b>
Item Name: Long Basket Assembly (350)				
Start Date: 4/29/14 Start Qty: 1.00	<b>*1*</b>	Cust Item ID:		
Required Date: 4/29/14 Req'd Qty: 1.00	<b>*1*</b>	Customer:		
Reference:				

Approvals: Process Plan: <u>MLJ</u> Date: <u>14-04-10</u>	Tooling: _____ Date: _____	Run Start	<b>*NR1*</b>
QC: _____ Date: _____	SPC (Y/N): _____ Date: _____	Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4030	D	<del>xsp</del> <u>label entry</u>							
100	Pick Kit	0.00							
<b>*100*</b>									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
<b>*110*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
28  
9-88

14 — 14-5-7

1x q 14 1403/12

DAS  
27  
9-89  
4/5/12

1 — — — —

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Item ID: D4030-041

Revision ID:

Item Name: Long Basket Assembly (350)

Start Date: 4/29/14 Start Qty: 1.00 \*1\*

Required Date: 4/29/14 Req'd Qty: 1.00 \*1\*

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*130\***

Packaging

Memo

PPP115635

0.00

Packaging

1/4 DAS MAY 12 2014  
28  
9-88

140

QC21 - Final Inspection - Work Order Release

0.00

**\*140\***

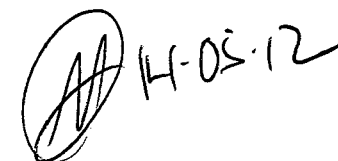
QC

Memo

0.00

Quality Control

MLJ 14-05-13



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**\*115973\***

**\*D4030-041\***

**Required Qty: 1.00**

**Comments:** IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D| 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530		Manufactured	No			100	Each	9.0000	1	1			
<b>*D2530*</b>									<b>**</b>				DAS
Handle Weldment													26
													9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST255			9					
					100754			6					
					110029			3					
D2535		Manufactured	No			100	Each	99.0000	2	2			
<b>*D2535*</b>									<b>**</b>				DAS
Spring													26
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			9-89
					ST011			99					
					100552			49					
					110374			50					
D2537		Manufactured	No			100	Each	151.0000	2	2			
<b>*D2537*</b>									<b>**</b>				DAS
Bushing													26
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			9-89
					ST011			151					
					103608			7					
					103861			42					
					110274			24					
					112958			40					
					113174			38					

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**\*115973\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/29/14

Required Date: 4/29/14

Start Qty: 1.00

Required Qty: 1.00

D3913-041 Manufactured No

100 Each 0.0000 1 1

**\*D3913-041\***

Long Basket Base Assembly, 350

**\*\***

B115715(1x) del 11/6/12

D3914-041 Manufactured No

100 Each 0.0000 1 1

**\*D3914-041\***

Long Basket Lid Assembly (350)

**\*\***

B115670(1x) del 11/6/12

D3917-3 Manufactured No

100 Each 109.0000 6 6

**\*D3917-3\***

Washer

**\*\***

DAS  
26  
9-89

Location

Loc Qty

Loc Code

ST070

109

104859

71

109114

38

6x

D3953-3 Manufactured No

100 Each 61.0000 2 2

**\*D3953-3\***

Gas Spring Stud, Lid

**\*\***

DAS  
26  
9-89

Location

Loc Qty

Loc Code

ST075

61

112504

37

112745

24

2x

D3953-7 Manufactured No

100 Each 75.0000 2 2

**\*D3953-7\***

Spring Spacer

**\*\***

14-5-7

DAS  
26  
9-89

Location

Loc Qty

Loc Code

ST075

75

102928

17

105465

11

109115

47

2x

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**\*115973\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/29/14

Required Date: 4/29/14

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each 61.0000 2 2

**\*D3953-9\***

Gas Spring Washer

\*\*

DAS  
26  
9-89

Location

Loc Qty

Loc Code

ST075

37

107922

17

112486

18

94719

2

ST076

24

113774

12

113775

12

D3953-17 Manufactured No

100 Each 11.0000 2

**\*D3953-17\***

Gas Spring Spacer

\*\*

DAS  
26  
9-89

Location

Loc Qty

Loc Code

ST076

11

106073

11

~~D3953-19~~

Manufactured No

100 Each 28.0000 1 1

**\*D3953-19\***

Gas Spring Bracket

\*\*

DAS  
26  
9-89

Location

Loc Qty

Loc Code

ST076

28

104984

18

107604

10

D3953-21 Manufactured No

100 Each 18.0000 1 1

**\*D3953-21\***

Gas Spring Bracket

\*\*

DAS  
26  
9-89

Location

Loc Qty

Loc Code

ST076

18

107641

18

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Work Order ID: 115973

**\*115973\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/29/14

Required Date: 4/29/14

Start Qty: 1.00

Required Qty: 1.00

D3969-3

Manufactured No

100

Each

54.0000

1

1

**\*D3969-3\***

Gas Spring

**\*\***

DAS  
26  
9-89

Location

Loc Qty

Loc Code

ST262

54

100611

18

110088

8

114957

18

99623

10

AN3-14A

Purchased No

100

Each

183.0000

4

4

**\*AN3-14A\***

Bolt

**\*\***

DAS  
26  
9-89

Location

Loc Qty

Loc Code

ST351

108

m127044

58

m128429

50

ST511

75

m127815

75

AN3-16A

Purchased No

100

Each

125.0000

2

2

**\*AN3-16A\***

Bolt

**\*\***

DAS  
26  
9-89

Location

Loc Qty

Loc Code

GA

44

117441

44

ST352

31

M126192

31

ST511

50

M127070

50

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Work Order ID: 115973

**\*115973\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/29/14

Required Date: 4/29/14

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

390.0000

4

4

**\*AN5-17A\***

Bolt

\*\*

2x m128978.

DAS  
26  
9-89

Location

Loc Qty

Loc Code

GA

36

117872

36

ST337

150

m128403

150

st503

150

125388

150

ST514

54

m126176

54

AN4-12

Purchased

No

100

Each

116.0000

3

3

**\*AN4-12\***

Bolt

\*\*

2x

DAS  
26  
9-89

Location

Loc Qty

Loc Code

ST356

116

m125709

16

m127817

50

m128403

50

3x

AN310-4

Purchased

No

100

Each

207.0000

3

**\*AN310-4\***

Nut

\*\*

③

m128818.

DAS  
26  
9-89

14-5-7.

Location

Loc Qty

Loc Code

ST342

207

M126872

7

M127815

25

M128429

25

M128650

150

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Work Order ID: 115973

**\*115973\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/29/14

Required Date: 4/29/14

Start Qty: 1.00

Required Qty: 1.00

AN310C4	Purchased	No	100	Each	177.0000	2	2		<b>DAS</b>
<b>*AN310C4*</b>								<b>**</b>	<b>26</b>
Nut									<b>9-89</b>

Location

Loc Qty

Loc Code

ST342

177

M125952

27

M127817

50

M128429

13

M128489

33

M128537

4

M128739

50

MS21042L3	Purchased	No	100	Each	3,010.000	6	6		<b>DAS</b>
<b>*MS21042L3*</b>								<b>**</b>	<b>26</b>
Nut									<b>9-89</b>

Location

Loc Qty

Loc Code

ST314

2055

M127410

1014

M127831

41

M128401

1000

ST506

955

123900

955

MS21042L5	Purchased	No	100	Each	702.0000	4	4		<b>DAS</b>
<b>*MS21042L5*</b>								<b>**</b>	<b>26</b>
Nut									<b>9-89</b>

Location

Loc Qty

Loc Code

GA

5

117611

5

ST315

197

m127304

197

ST509

500

m127813

500

14-5-7-  
m128810.

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Work Order ID: 115973

**\*115973\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/29/14

Required Date: 4/29/14

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

474.0000

3

3

**\*MS24665-151\***

**\*\***

Cotter Pin

Location

Loc Qty

Loc Code

GA

29

17566

29

ST323

445

125646

2

m127305

43

m128401

400

MS24665-300

Purchased

No

100

Each

66.0000

2

**\*MS24665-300\***

**\*\***

COTTER PIN

Location

Loc Qty

Loc Code

GA

30

118234

30

ST299

36

124555

36

NAS1149F0432P

Purchased

No

100

Each

2,980.000

6

6

**\*NAS1149F0432P\***

**\*\***

WASHER

Location

Loc Qty

Loc Code

ST295

2923

125268

32

M127813

3

M128429

2000

M128591

888

ST510a

57

M126221

57

DAS  
26  
9-89

DAS  
26  
9-89

DAS  
26  
9-89

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Work Order ID: 115973

**\*115973\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/29/14

Required Date: 4/29/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

407.0000

4

4

**\*NAS1149F0563P\***

**\*\***

Washer

DAS

26

9-89

Location

Loc Qty

Loc Code

ST295

407

121350

407

NAS1149F0332P

Purchased

No

100

Each

7,230.000

8

8

**\*NAS1149F0332P\***

**\*\***

Washer

DAS

26

9-89

Location

Loc Qty

Loc Code

GA

205

122063

205

ST295

2558

123900

12

m123185

46

m128401

2500

ST510a

4421

125646

1921

m127831

2500

ST522

46

m123185

46

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Work Order ID: 115973

**\*115973\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/29/14

Required Date: 4/29/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

4,198.000

2

2

**\*NAS1149C0432R\***

WASHER

**\*\***

14-5-7

DAS  
28  
9-89

Location

Loc Qty

Loc Code

GA

1719

m125807

1719

ST292

88

119124

6

121255

3

122441

79

ST510a

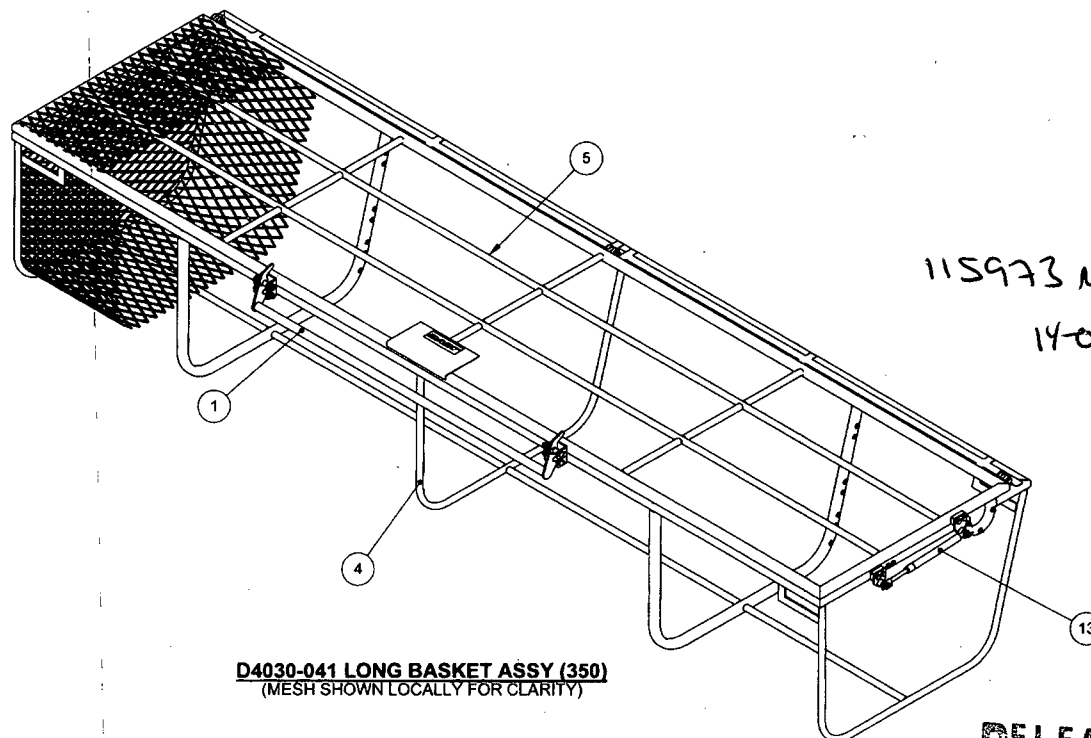
2391

m126221

2391

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
2x

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4030-041	LONG BASKET ASSY (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT, MACHINE
15	2	AN3-16A	BOLT, MACHINE
16	3	AN4-12	BOLT, MACHINE
17	4	AN5-17A	BOLT, MACHINE
18	2	AN310C4	NUT, PLAIN, CASTELLATED
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	6	MS21042L3	NUT, SELF-LOCKING
21	4	MS21042L5	NUT, SELF-LOCKING
22	2	MS24665-300	COTTER PIN
23	3	MS24665-151	COTTER PIN
24	2	NAS1149C0432R	WASHER
25	6	NAS1149F0432P	WASHER
26	8	NAS1149F0332P	WASHER
27	4	NAS1149F0563P	WASHER

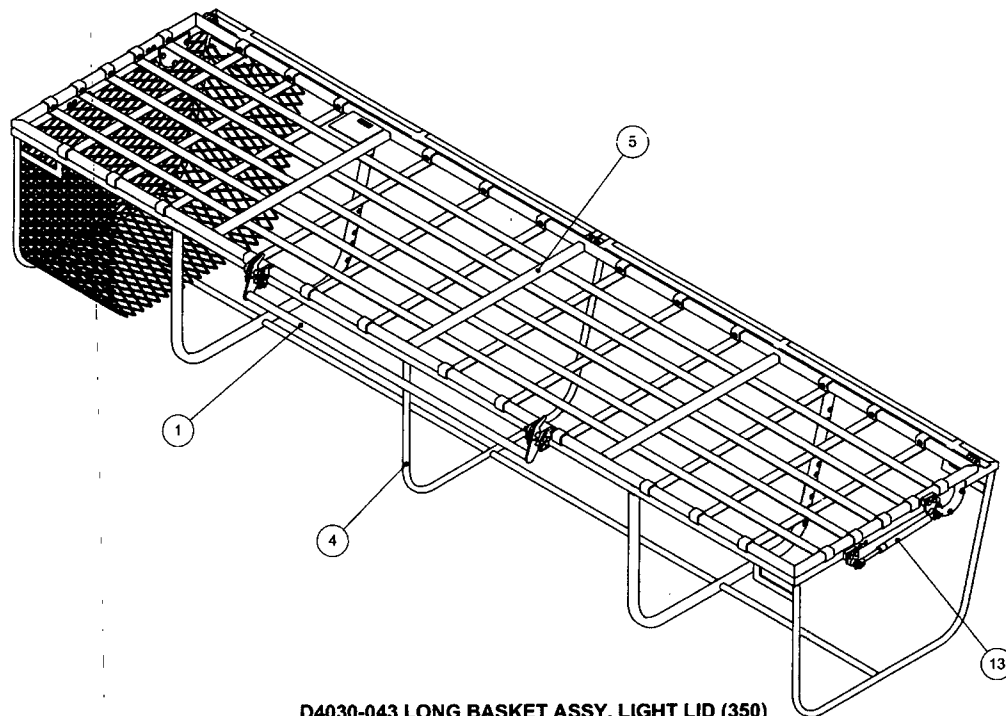


**D4030-041 LONG BASKET ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 72 lbs APPROX

D	REFORMAT FOR CLARITY. PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18
C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. D
MFG. APPR.	AS	D4030	SHEET 1 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT
15	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	4	NAS1149F0563P	WASHER
27	8	NAS1149F0332P	WASHER
28	2	NAS1149C0432R	WASHER



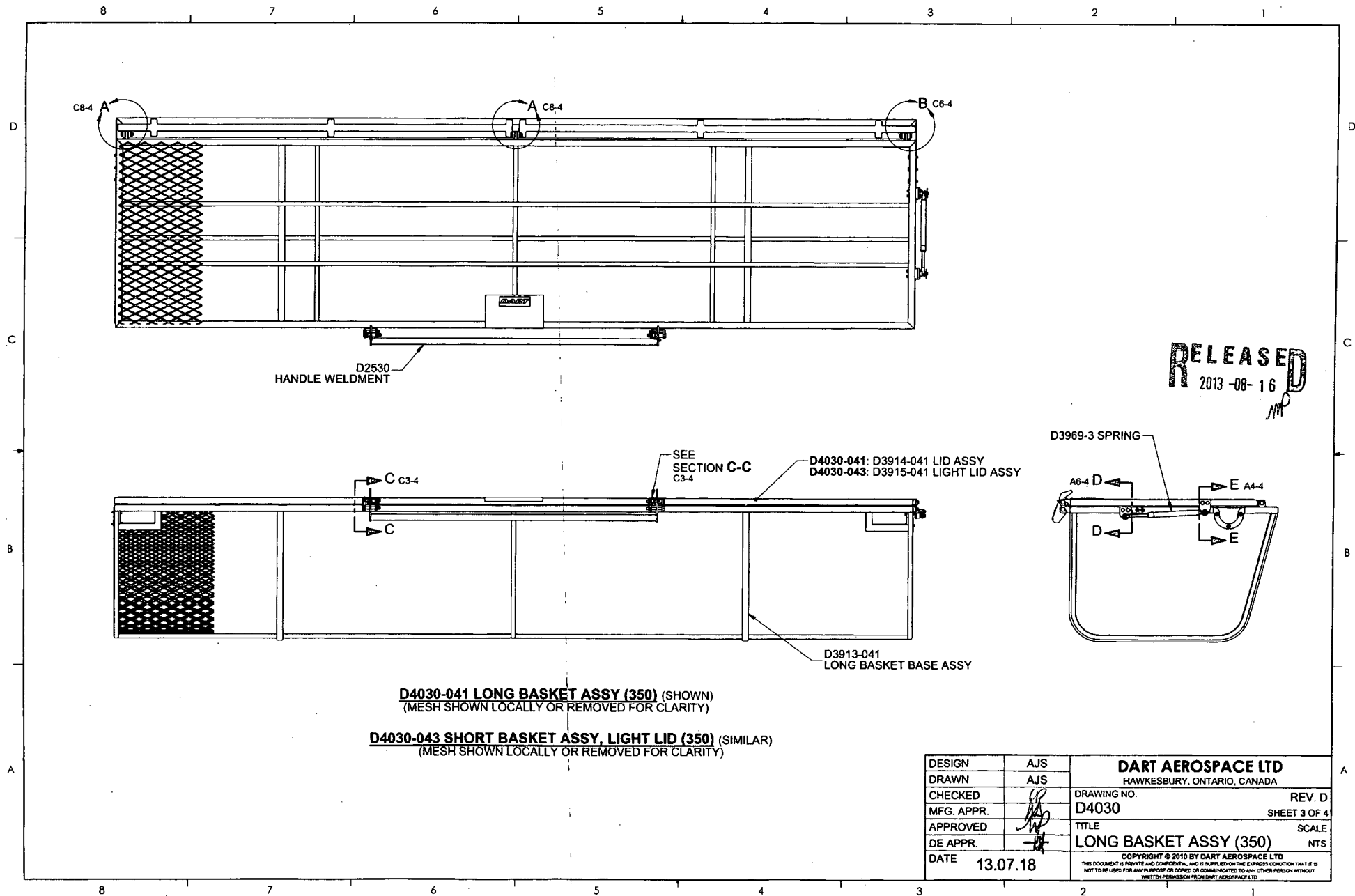
**D4030-043 LONG BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2013-08-16  
MP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 57 lbs APPROX

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	13.07.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



8

7

6

5

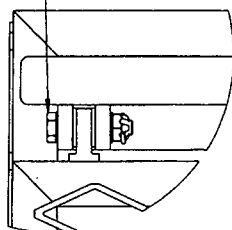
4

3

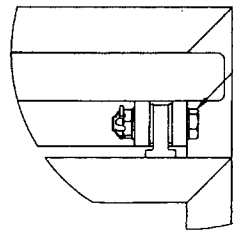
2

1

AN4-12 BOLT, MACHINE  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



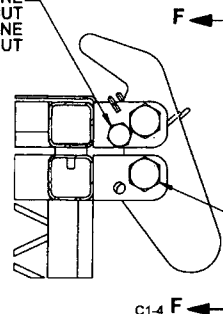
**DETAIL A** D8-3  
D5-3



**DETAIL B** D3-3

AN4-12 BOLT, MACHINE  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN

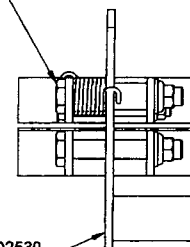
D4030-041: AN3-16A BOLT, MACHINE  
MS21042L3 NUT  
D4030-043: AN3-20A BOLT, MACHINE  
MS21042L3 NUT



**SECTION C-C** B4-3  
B6-3

D4030-041: AN5-17A BOLT, MACHINE  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT  
D4030-043: AN5-21A BOLT, MACHINE  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

AN5-17A BOLT, MACHINE  
NAS1149F0563P WASHER  
MS21042L5 NUT



D2530  
HANDLE WELDMENT  
REF

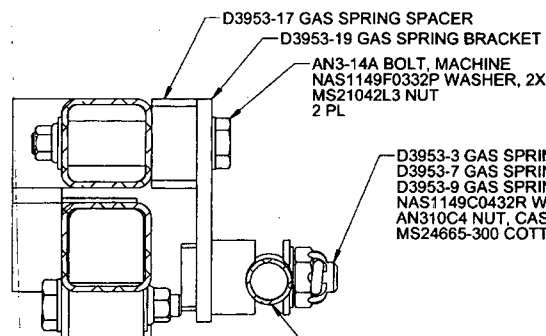
**VIEW F-F** C3-4

D3953-17 GAS SPRING SPACER  
D3953-21 GAS SPRING BRACKET  
AN3-14A BOLT, MACHINE  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION D-D** B2-3



D3953-17 GAS SPRING SPACER  
D3953-19 GAS SPRING BRACKET  
AN3-14A BOLT, MACHINE  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL  
D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION E-E** B1-3

**RELEASED**  
2013-08-16  
M

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MFG. APPR.		D4030	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
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